540

DART AEROSPACE LTD

Work Order: 34204

Description: Hi – Step Leg Assembly

Part Number: D3065-041

Dwg: D3065 Rev. At A2

Qty: 30 U
Pros. oz. 17 Pros. oz. 28

Page 1 of 2

Step	Location	Procedure	D.	Data	04:
1	DC	Issue Traveller Dwg. not required RF 02.11.04	By	05/09/07	Qty
,		(Minimum lots of 30)	30	23/01/01	5
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500")			<b>-</b>
}		Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick		1	
İ		(M2024T3S.040) Batch <u>M 11948</u>	1 7 6	05-09-27	30
3	MV	Identify as D3065-1 4.320" RF 02.11.29 4.320"	J		
3	1010	Cut blanks: 6.600" x 4.250" (grain along 4.320") (4.250")		-	
İ		Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick 62-41-25 (M2024T3S.040)  Batch M139486	<b>5</b>	· ·	
		(M2024T3S.040) Batch M179Y8r ldentify as D3065-3	J.C	05.09.28	30
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500")	-	00.07.28	<del> </del>
		Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick			
		(M2024T3S.040) Batch M1794%			30
		Identify as D3065-7	J.L	05.09.27	
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg.	1		<del>                                     </del>
	1	Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick		4	
,	1	(M5052H32S.080) Batch <u>M 83 88</u>			10
		Identify as D3065-5	3.L	05.09.28	60
6	MV	(Note: make 2 legs per assembly)		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
	IVIV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010)		1,5	
		Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M/\$3\$\$\times\$			1
		Identify as D3066 1			1/0
•		(Note: make 2 spacers per assembly)	JL	05.10.06.	60
7 ·	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use	├		
•	<u></u>	stack of 15.	J.L	05.10.02	30
8	MV	Deburr to take measurement	<del> </del>	03,701.04	
			ふし	05.10.02	30
9 .	QC2	Inspect parts as they come off the CNC machine			
40	000		J.L	02-10-02	30
10	QC8	Second check			
11	MV	Machine D2065 2 on marfelia FA400 I.D. Deces	5	05/10/02	30
• •	1010	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.			24
12	MV	Deburr to take measurement	1.4	02-10-07	30
		Dobait to take measurement	۲.۷	05.10.02	30
13	QC2	Inspect parts as they come off the CNC machine	7,7	03.70.02	
		map and do may come on the orto machine	J.L	50.01,20	30
14	QC8	Second check		77,010%	
			Es	05/10/02	30
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use		05.1010	
		stack of 15.	JL	£0.01.20	30
16	MV	Deburr to take measurement			~ _
4-	000		JL	05.10.02	30
17	QC2	Inspect parts as they come off the CNC machine		:	
18	QC8	Second check	J.L	02-10-09	<u>30</u>
10	QC0	Second check	En		2 .
1/9	MV/	Machine D3065-5 as per folio FA1/79 and Dwg/D3065, use	7	05/10/22	30
		stack of 10.	/		

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9.24

05.03.09

RELEASED

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES		*****	-		
DATE STEP		PROCEDURE CHANGE B	у	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
<i>i</i> .		•				Ļ	
		Ş					

NCR:		W	ORK OR	DER NON-CONFORMANCE (NCR)		,	
,		Description of NC		Corrective Action Section B	Verification	Annroyal	Annroyal
DATE	STEP	Section A	Initial Design Mgr	Action Description Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
				, * :			
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				0			
		•					
		•					
			-	. ,			

Part No:	PAR #:	Fault Category: _	·: N	NCR:	Yes No DQA:	Date: <u>05///</u> ©
NOTE: Date & initial all entries					QA: N/C Closed:	Date:

DART AEROSPACE LTD	Work Order:	24204
Description: Hi – Step Leg Assembly	Part Number:	D3065-041
Pf 03,02,28		
Dwg: D3065 Rev. At A2	Qty:	30
RF-03-00-17		Page 2 of 2

Step	Location	Procedure	Ву	Date	Qty
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	J.L	05.10.03	60
20	MV	Deburr to take measurement	J.L	05-10.03	60
21	QC2	Inspect parts as they come off the CNC machine	J.L	05-10-03	60
22	QC8	Second check	Er	65/16/07	60
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	JL	05-10-06	60
24	MV	Deburr to take measurement	2.0	05-10.06	60
25	:QC2	Inspect parts as they come off the CNC machine	スし	05.10.06	60
26	QC8	Second check	E	05/10/06	60
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.		×10/26	30
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065		05/10/26	
29	QC5	Inspect work to Step 28	1	5-10-27	30
30	FP	Chemical conversion coat as per QSI 005 4.1	DL	05/10/27	30
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly.  Oty Part Number Description 1 D3065-1 Spacer B 24204 1 D3065-3 Spacer B 24204 2 D3065-5 Leg B 24204 1 D3065-7 Spacer B 24204 30 MS20470AD4-4 Rivet H 17405		05/11/62	30
32	QC5	Inspect work to Step 31		2.11.07	30
33	GA , ,	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer	5B	Fol 11   20	30
34	AC	Cost / part 4 4 4 4 4 6 6 6 6 6 6 6 6 6 6 6 6 6 6	545	05-//-0	1
35	DC	Close W/O 40,9 4 Inspect Level 21	0	05)11/08	30

Rev	Date	Change	Revised By	Approved
Α	01.12.10	New Issue	SM	
В	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	-1
С	02.11.01	Incorporated D3066-1 IPP	KJ K	all



# Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES			· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
							4
							Ť
		WORK OPDED NON CONE					

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Design Mgr	
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C		Approval QC Inspector
	28							
						:		
					-			
		•						
			·					,

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				,QA: N	/C C	osed:	Date:

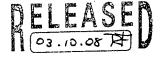
D3065-5DART AEROSPACE LTD	Work Order:	24204
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.250	+/-0.010					
2.093	+/-0.010	A CONTRACTOR OF THE CONTRACTOR				
3.936	+/-0.010					1/45
4.186	+/-0.010	***				
0.587	+/-0.010			·		
Ø0.128	+0.005 -0.000					
R0.125	+/-0.010					01/692
3.465	+/-0.010				1/	19401
Ø1.250	+0.005 -0.000				77	1
0.368	+/-0.010			W2		
0.871 (Pitch)	+/-0.005		M )			
			1100			
		12				
						• ·
					·*	

Measured by: ょし	Audited by:	Es	Prototype Approval:	N/A
Date: 05.10.02	Date:	05/10/02	Date:	03.10.08

Rev	Date C	hange		Revised by	Approved
A 03	.09.22 N	lew Issue	Plo D3065-041	KJ/RF	72



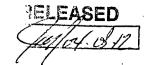
D3065-5DART AEROSPACE LTD	Work Order:	24204	
Description: Step Spacer	Part Number:	D3065-3	
Inspection Dwg: D3065 Rev: A2		Page 1 of 1	

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
1.260	+/-0.010						
3.260	+/-0.010						
5.260	+/-0.010						
6.520	+/-0.010				1. 1		
2.093	+/-0.010				_		
3.936	+/-0.010		· · · · · · · · · · · · · · · · ·	α	7		
4.186	+/-0.010			10			
Ø0.128	+0.005/-0.000			1		,	
Ø1.250	+0.005/-0.000		11) }				
Pitch 1.204	+/-0.005		10				
		5					
		D>					
			/				
	Ma						
	120						

Measured by:	J-L	Audited by:	Til	Prototype Approval:	N/A
Date:	05-10-02	Date:	05/10/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue P/O D3065-041	KJ/RF	01
В	04.08.12	Removed dimension 1.204	KJ/JLM	1/10/1
				7



D3065-5DART AEROSPACE LTD	Work Order:	24201
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	roteratice	Dimension	Accept	Reject	Inspection	Comments
16.458	+/-0.010					
15.750	+/-0.005	7.				
2.250	+/-0.005					
3.460	+/-0.005					
0.865	+/-0.005				a	
6.020	+/-0.005			,	ROM	
1.205	+/-0.005					
3.484	+/-0.005					
0.871	+/-0.005		1	1		
8.325	+/-0.010					
0.551	+/-0.010		110	,		
0.213	+0.005/-0.000		$\mathcal{V}$			
Ø0.128	+0.005/-0.000					
		CV>				
		J				,
	1					
	M					
	V.D.					
	13					
	1					
3 - Marie - Ma						

Measured by:	L	Audited by:	* 80	Prototype Approval:	N/A
Date: 05	5.10.03	Date:	05/10/06	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	P/O D3065-041	KJ/RF	01
В	04.06.15	Added Ø0.128	dimension	KJ/JLM	& RIII

RELEASED
OY-CO-17

D3065-5DART AEROSPACE LTD	Work Order:	24204
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.000					
0.865 (Pitch)	+/-0.005					
4.522	+/-0.010	,				
0.250	+/-0.010				02	)
2.093	+/-0.010					
3.936	+/-0.005					
4.186	+/-0.010					
Ø1.250	+/-0.005		-			
R0.125	+/-0.010					
Grain Direction	N/A		)1			
			7			
		A)				
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Measured by:	J.L	Audited by:	Er	Prototype Approval:	N/A
Date:	10.003	Date:	05/40/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	1
В	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	

RELEASED

D3065-5DART AEROSPACE LTD	Work Order:	24/204	
Description: Spacer	Part Number:	D3066-1	
Inspection Dwg: D3066 Rev: A		Page 1 of 1	

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000					
0.708	+/-0.010					
0.358	+/0.010			$\cap$		
0.350	+/0.010		<i>C</i> '			
2.250 (Pitch)	+/-0.005		, 2	\		
16.450	+/0.010					
			1/0			
			,			
			V			
		$\mathcal{L}$				- 22.4
	W	/				
	$\vee$					
6						
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		*****				

Measured by:	JL	Audited by:	En	F
Date:	05.10.06	Date:	05/10/06	

Prototype Approval:	N/A
Date:	03, 10.08

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	P/o D3065-04-1	KJ/RF	



#### Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Sep 02, 2005 🚁 09:01 am

Work Order No : 0024204

Project Name Project For : D3065-041

: WK540 Work Order Type : Main

Main WO Number

House Part Number : D3065-041

Description : Step Leg Assembly

Manufactured : Yes

Amount Req'd :

Amount Done :

: 09-01-05 Start Date Est Finish Date : 10-06-05

Act Finish Date

Drawings Reqd : No Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN

WO Status ·: Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No:

OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

<u> </u>		Estimated	Actual	Var. %		Posted	To	Post
Material Cost	:	0.00	€0.00	0.00	1	0.00		0.00
Engineering Hours	:	0.00	0.00	0.00		`*		•
Engineering Cost	:	0.00	0.00	0.00		0.00		0.00
Production Hours	:	0.00	0.00	0.00				
Production Cost	:	0.00	0.00	0.00		0.00		0.00
Packaging Hours	:	0.00	0.00	0.00				
Packaging Cost	:	0.00	0.00	0.00		0.00		0.00
OverHead Hours	:	0.00	0.00	0.00		-		er e
OverHead Cost	:	0.00	0.00	0.00		0.00		0.00
CNC Hours	:	0.00	0.00	0.00		4		•
CNC	:	0.00	0.00	0.00		0.00		0.00
Misc. Hours	:	0.00	0.00	0.00				
Misc:	:	0.00	0.00	0.00		0.00		0.00
		=======================================	========	======				
Burden	:	0.00	0.00	0.00				
		=========	=======	======				
Total Cost	:	0.00	0.00	0.00				
Mark up	2	0.000	0.000					
Selling Cost	:	0.00	0.00	•				٠,
								•

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) 0.00 0.00

#### Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Nov 08, 2005

11:10 am

Work Order No : 0024204

Project Name : D3065-041 Project For : WK540

Work Order Type : Main

Main WO Number :

House Part Number: D3065-041
Description: Step Leg Assembly

Manufactured : Yes

Amount Req'd: 30
Amount Done: 0
Start Date: 09-01-05

Est Finish Date : 10-06-05

Act Finish Date : Drawings Reqd : No

Ok for Approval : Approval Rec'd :

Order Entry No : OE Value : 0.00

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Department Code:

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	55.62	100.00	•	
Production Cost	:	0.00	1043.05	100.00	0.00	1043.05
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	17.13	100.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
		=======	=======	======		

100.00

Total Cost Margin : 0.00 1043.05 : 0.000 0.000 Selling Cost : 0.00 1043.05

Labour Hrs/Amount Done : 0.00
Profits/(Loss) : 0.00 Actual 0.00 0.00 ( -1043.05)